

Work Order ID 84738

84738

Page 1

May-22-12 12:52:28 PM

Item ID: D2221 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 350 Basket Base
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 29/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								

100 Large Fab 0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
- 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
- 3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M122130

PLEASE NOTE

IF MAKING -041A OR -043A :
 DRILL HOLES FOR GAS SPRING
 IN D3825-041 AS PER
 DSI 9473

CP 12.9.4

1x *Ø*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1 *Ø*

12-09-04

DAS 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-22-12 12:52:28 PM

Item ID: D2221

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 350 Basket Base

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 29/05/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>D350 602041</i>	0.00	<i>82160</i>			<i>1</i>	<i>0</i>	<i>12-9-5</i>	
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/9/11 *MF*
12-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 84738

84738

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				80163		1							
D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				67117		2							
				78637		4							
D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		4							
				81041		4							

**

**

**

Pl 12 9 4

382950

Pl 12 9 4

B84793 → ②

Pl 12 9 4

①

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Page 2

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84738

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each 15.0000 2 2

D2232-3

Basket Hinge

**

Location	Loc Qty	Loc Code
WA	13	
82304	13	
WA005	2	
75581	2	

PL12.9.4
386362 → ①
385678 → ①

D2235-1 Manufactured No

100 Each 20.0000 2 2

D2235-1

Basket Rib

**

Location	Loc Qty	Loc Code
WA	16	
78636	5	
81910	1	
82951	10	
WA005	4	
66895	4	

PL12.9.4
386669 → ②

D2581 Manufactured No

100 Each 76.0000 2 2

D2581

Mounting Bracket

**

Location	Loc Qty	Loc Code
WA	22	
82506	2	
83230	20	
WA005	54	
70766	2	
81253	1	
82017	11	
82897	40	

PL12.9.4
385452 → ②

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3442-1
Shim
D3442-1

Manufactured No

100 Each 23.0000 2 2

**

Location

Loc Qty

Loc Code

WA

20

80788

20

WA005

3

71783

3

Pl 12.9.4
B80788
~~B86660~~ → (2)

D3825-041
Rib Assembly (Basket End)
D3825-041

Manufactured No

100 Each 2.0000 2 2

**

Location

Loc Qty

Loc Code

WA

2

78638

2

Pl 12.9.4
B87755 → (2)

D3826-041
Rib / Gusset Assembly
D3826-041

Manufactured No

100 Each 4.0000 2 2

**

Location

Loc Qty

Loc Code

WA

4

83909

4

Pl 12.9.4
B87288 → (2)

D3827-041
Rib Assembly (Inboard)
D3827-041

Manufactured No

100 Each 8.0000 1 1

**

Location

Loc Qty

Loc Code

WA

6

81038

6

WA006

2

72729

1

77546

1

(1)

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Shop Packet Print

Page 3

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Page 4

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D2221

Parent Item Name: 350 Basket Base

Start Date: 22/05/2012

Required Date: 29/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3832-1

Manufactured No

100

Each

1.0000

1

1

D3832-1

Mesh (Base)

**

Location

Loc Qty

Loc Code

WA

1

84068

1

B87842 → ①

D3833-1

Manufactured No

100

Each

9.0000

2

2

D3833-1

Mesh (Base End Face)

**

Location

Loc Qty

Loc Code

WA

4

77521

4

WA035

5

81259

5

B85697 → ②

May-22-12 12:52:32 PM

Shop Packet Print

Page 4

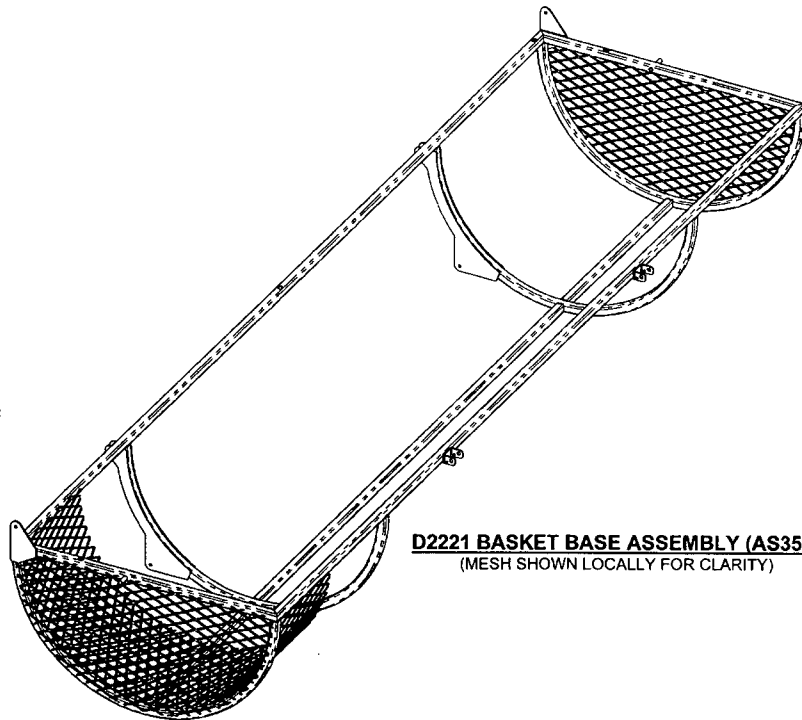
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84738MLJ
12/05/22

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2232-3; D3826-041 REPLACES D2235-1/D2235; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

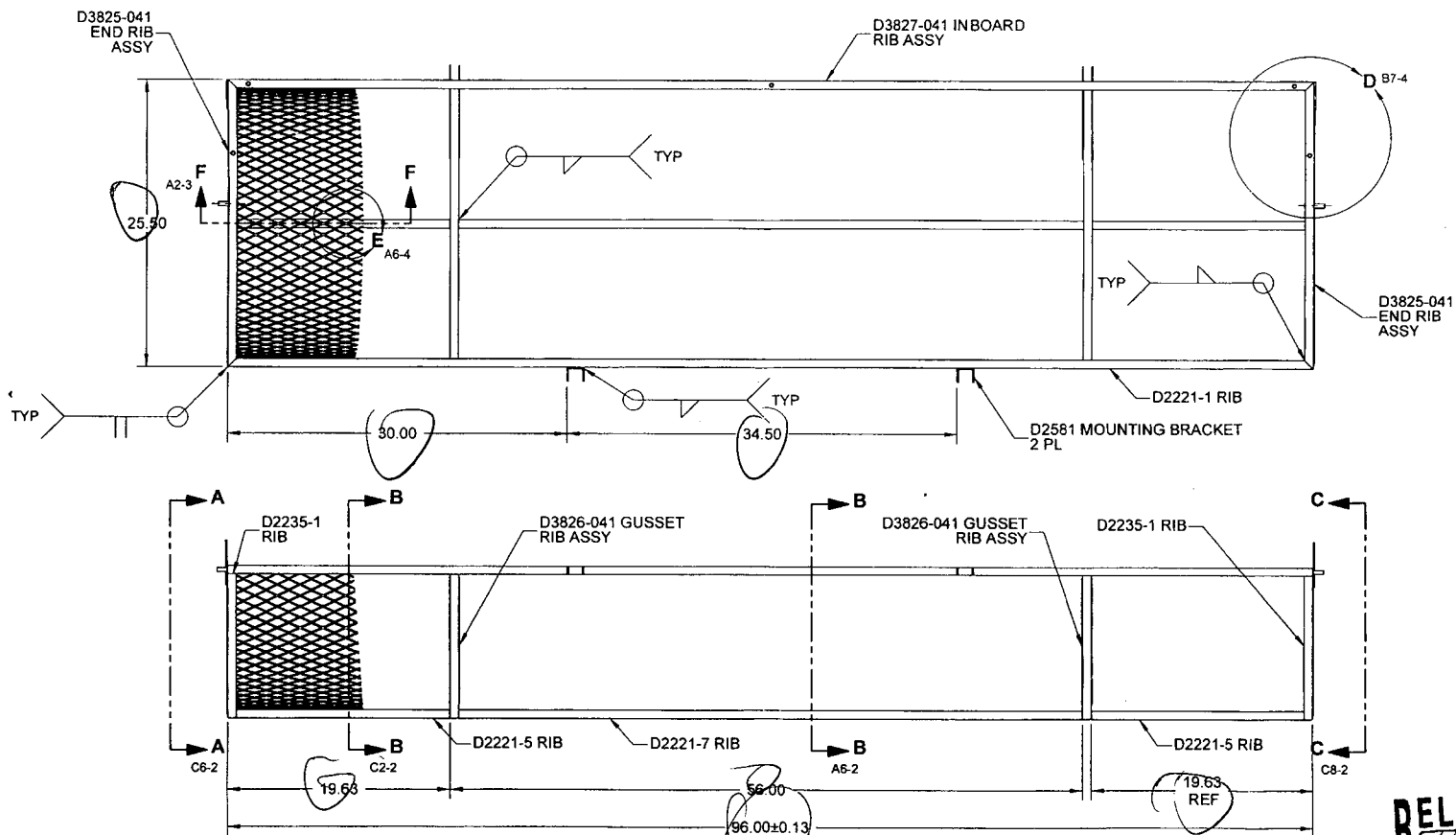
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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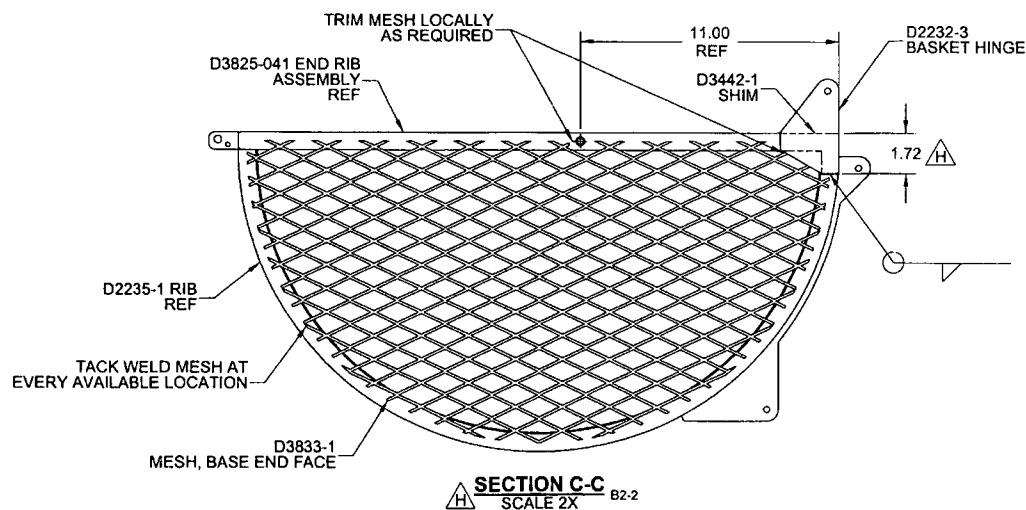
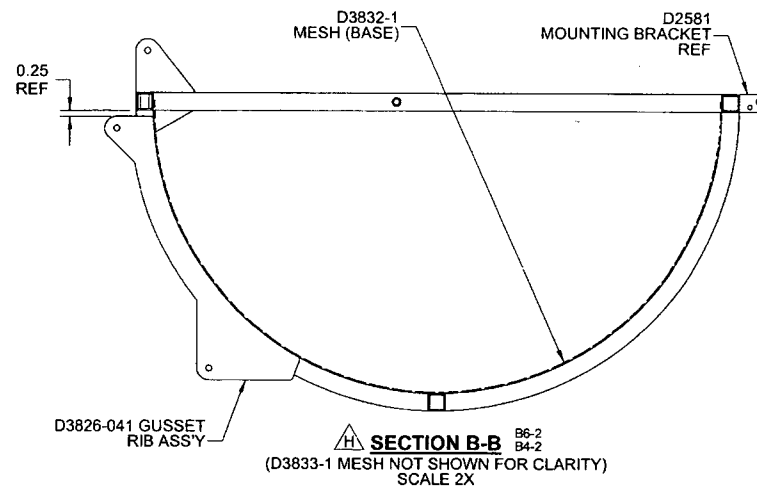
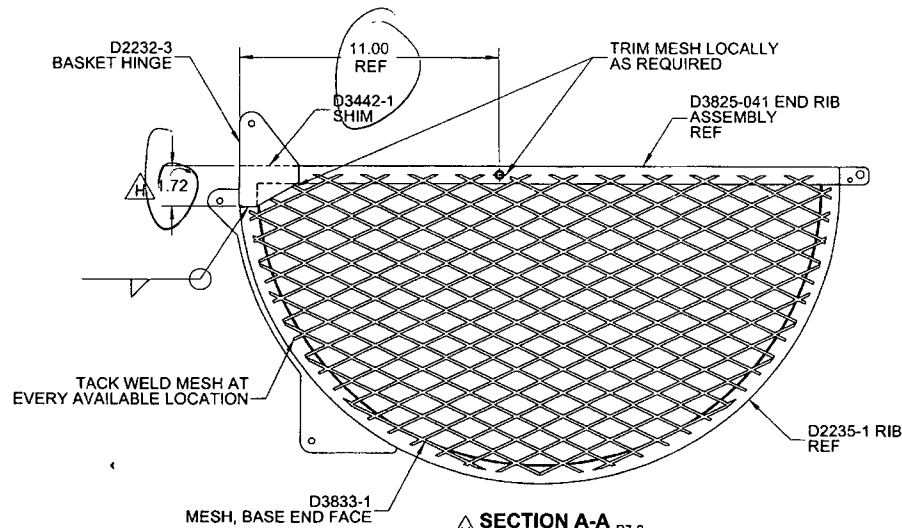
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NOTE: Date & initial all entries

04738



RELEASED
08/11/18

DESIGN	EW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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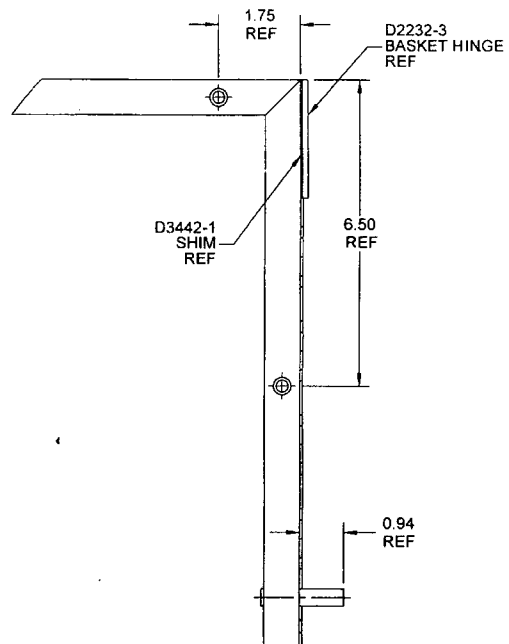
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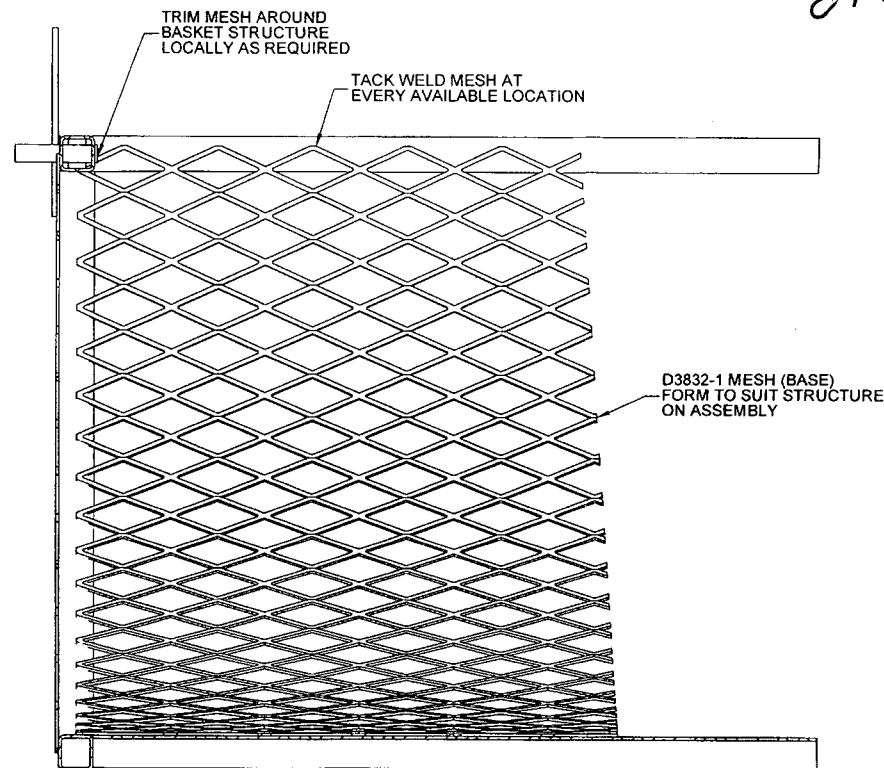
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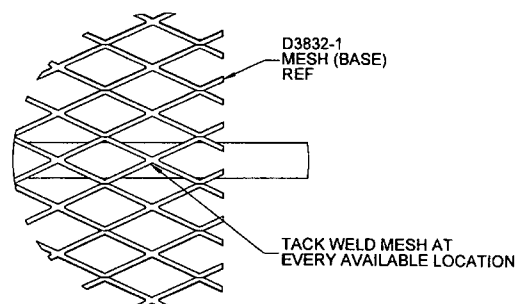
24738



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

RELEASED
02/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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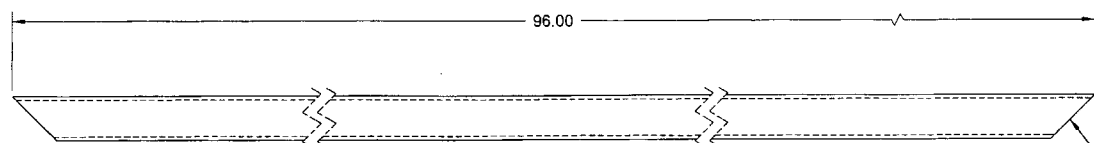
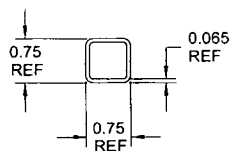
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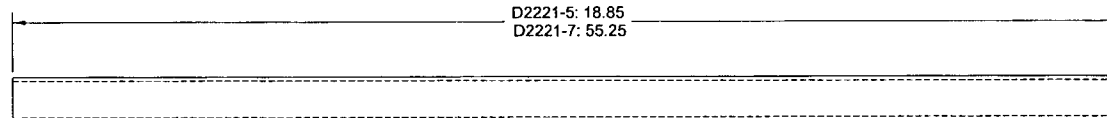
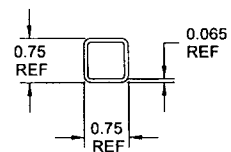
NOTE: Date & initial all entries

84738



0.75 X 45° CHAMFER
2 PL

D2221-1 RIB



D2221-5: 18.85
D2221-7: 55.25

D2221-5/-7 RIB

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MT	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries